

10/7/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

NCR-19-7489



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3512-041
Job Sheet 201578



Part No: D3512-041

Job Qty: 10 pcs

Part Name: Wearplate



Part Weight: 0 lbs

Status: New

Job Created: 10/7/19

Job Tracking No:

Due Date: 10/31/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: URF18-745 DWG-D3512-REV.D IPP REV:A 13.07.19 NEW ISSUE DD VERF:JLM IPP REV:B 13.12.11
ECN13-619/ REV.D DWG DD VERF:JLM IPP REV:C 18.03.12 DWG REV.E12 DD VERF:JFS IPP REV:D
18.10.12 BACK TO REV.D DD VERF:RG

Ship Via:

POSITIVE RECALL
EFFECTIVE 10/2 AUTH SAD
DAS
RELEASED 55 DATE OCT 09 2019
9-89 Priority: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Welded Assy-1	10 pcs	10/31/19	10/31/19	0.00	1.67	Large Fab - 1		<i>BC</i>
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
	<i>make from Rev E</i>						Large Fab - 11 (Various)		<i>BC</i>
120	Large Fab - Welded Assy-2-B4B	10 pcs	10/31/19	10/31/19	0.00	1.67	Large Fab - 1 - B4B		
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		
							Large Fab - 7 - B4B		
							Large Fab - 8 - B4B		
							Large Fab - 9 - B4B		
							Large Fab - 11 - B4B (Various)		<i>BC</i>
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
							QC 5 - 10		
140	QC 5	10	10/31/19	10/31/19	0.00	0.00	QC 5 - 10		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S220936

Part: D3512-041

Job No: 201578

Serial No/Batch: S220936

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Data: 10/08/19

Plex 10/7/19 3:17 PM Dart.lajeunesse.marie

10/7/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

pcs					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	EL
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
142 Spray Paint - 2 - B4B	10 pcs	10/31/19	0.00	1.00	Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	2019-10-8
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
144 QC 5	10 pcs	10/31/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	OCT 09 2019
					QC 5 - 61	DAS 40
					QC 5 - 81	8-89
150 Packaging 3-1 - Stock - B4B	10 pcs	10/31/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	

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10/7/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie



160 QC 21 - SA

10
pcs

10/31/19

0.00 0.00

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

DAS

QC 21 - SA - 21

21

QC 21 - SA - 70

9-89

QC 21 - SA - 53

OCT 09 2019

Part Op 110 - Weld per dwg A/R Hardcoat S.S. Batch: 2059B HARDCOAT BATCH: A137018

Descriptions: 120 - Weld per dwg A/R S.S. rod Batch:

130 - QC9- Inspect visual per QSI004- Fusion Welds

140 - QC5- Inspect part completeness to step on W/O

142 - Assemble as per dwg - Coat wearplate with rockguard as per Dwg and note #10 Batch: S211152

144 - QC5- Inspect part completeness to step on W/O

150 - Identify as per dwg & Stock Location:

160 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3512-1	Wearplate	10 pcs (1 ea)	110-Large Fab - Welded Assy-1	S219945
D3512-3	Spacer	10 pcs (1 ea)	110-Large Fab - Welded Assy-1	S219959

Job Allocations

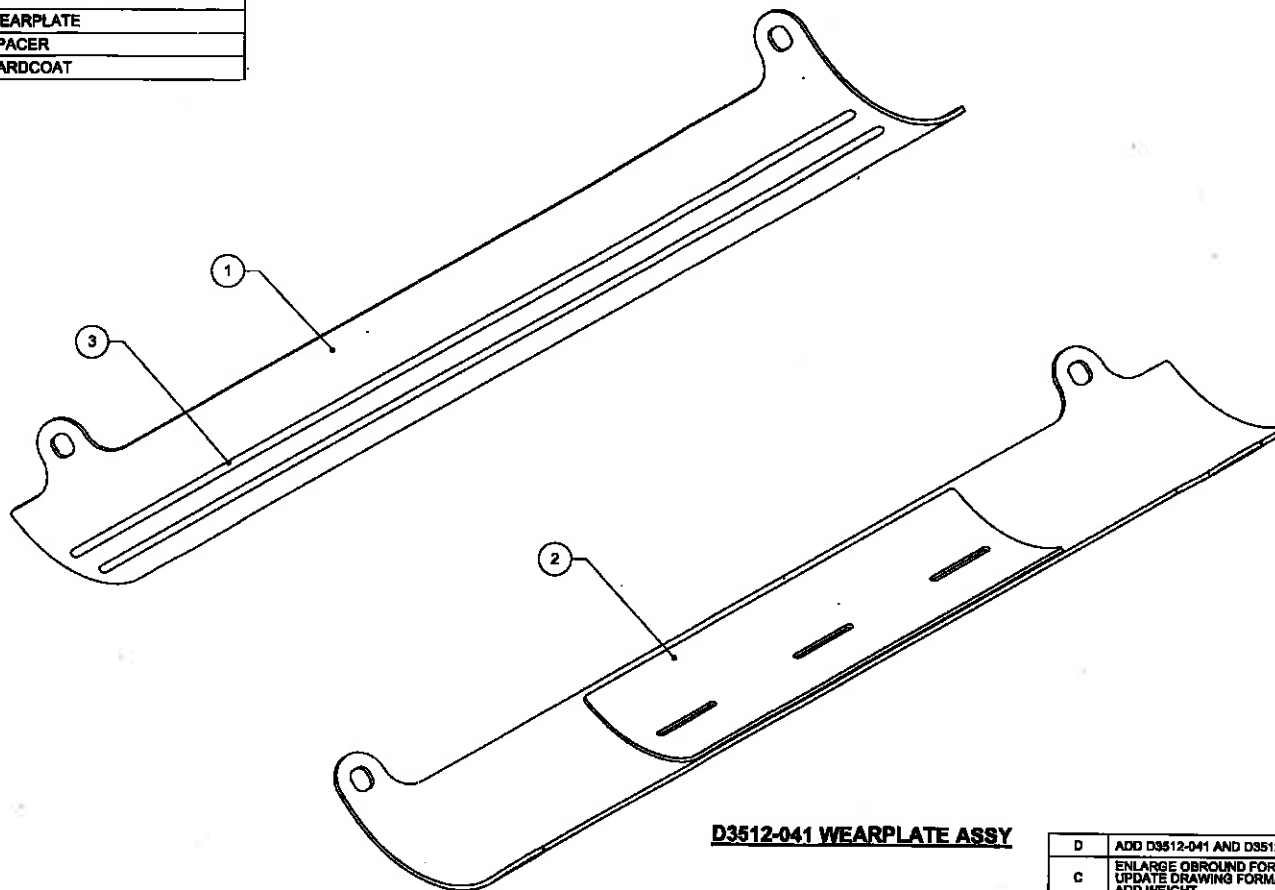
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Welded Assy-1	D3512-1	10	12	0
	D3512-3	10	15	0

Part Specifications

Specifications could not be found.

Plex 10/7/19 3:17 PM Dart.lajeunesse.marie

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3512-041	WEARPLATE ASSY
1	1	D3512-1	WEARPLATE
2	1	D3512-3	SPACER
3	A/R	20508	HARDCOAT



D3512-041 WEARPLATE ASSY

RELEASED
2013-12-10

UNDER REVIEW
URF18-745 SAD 18-06-19

REV.	DESCRIPTION	BY	DATE
D	ADD D3512-041 AND D3512-3	DW	13.08.28
C	ENLARGE ODBOUND FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3512 REV. D WEARPLATE ASSY SCALE NTS COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	DW		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	13.08.28		

8

7

5

3

2

1

C
SYM

3.86

TYP

D3512-3 SPACER

D3512-1 WEARPLATE

0.500

SECTION A-A
SCALE 1:1.50.25
TYP

UNDER REVIEW

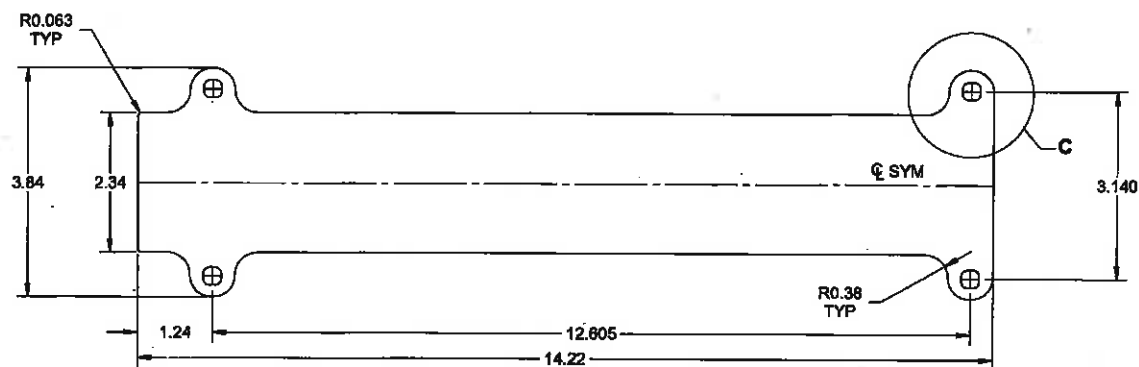
URF18-745 SAD 18-06-19

RELEASED
2013-12-10C
SYM**D3512-041 WEARPLATE ASSY****NOTES:**

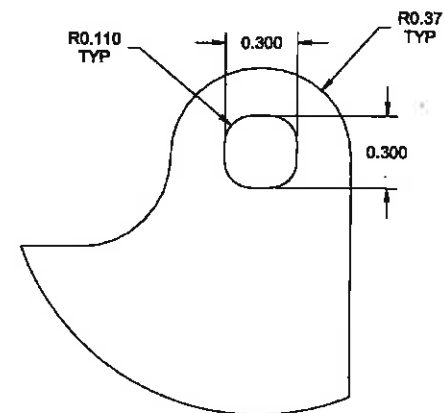
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3512-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.94 lbs
- 8) WELDING: PER QSI 004, 2059B HARDCOAT WELD 0.063 TO 0.125 THK
- 9) COAT HATCHED (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714, 0.020-0.040 THK

DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3512	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSY	NTS
DATE	13.08.28	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



D3512-1F



DETAIL C
SCALE 2X

UNDER REVIEW
URF18-745 SAD 18-06-19

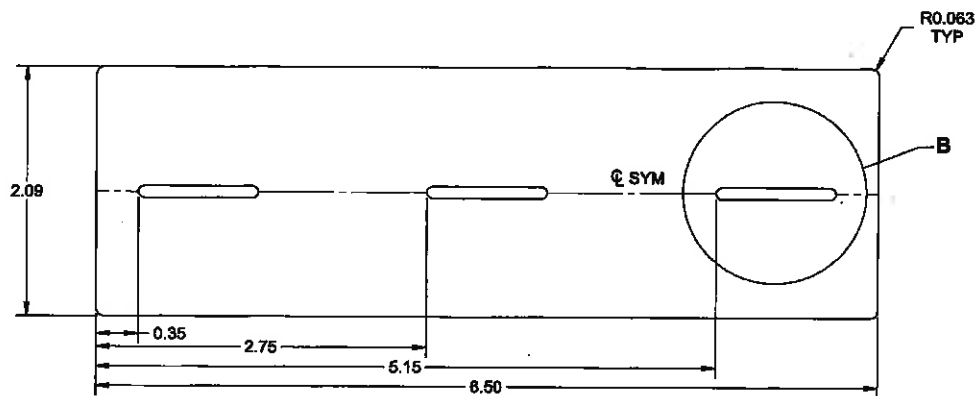
RELEASED
2013-12-10
WP

NOTES:

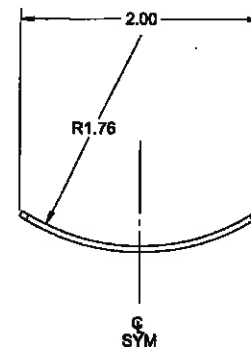
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240
18 GAUGE 0.063 THICK (REF DART SPEC. MS304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	MP	DRAWING NO.	REV. D
MFG. APPR.	MP	D3512	SHEET 3 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	WEARPLATE ASSY	NTS
DATE	13.08.28	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

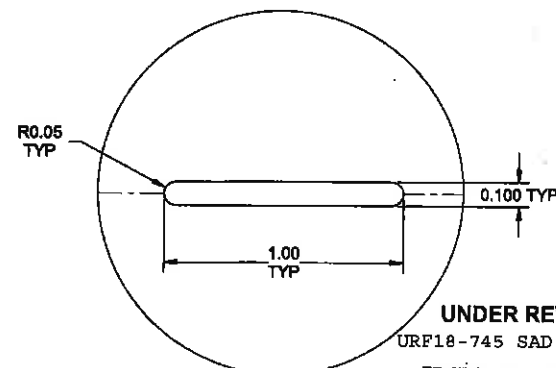
8 7 6 5 4 3 2 1



D3512-3F FLAT PATTERN



**D3512-3 SPACER
MAKE FROM D3512-3F**



**DETAIL B
SCALE 2X**

UNDER REVIEW
URF18-745 SAD 18-06-19

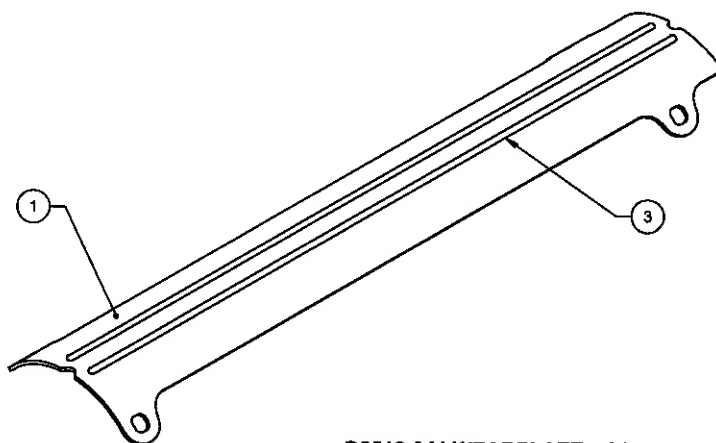
RELEASED
2013-12-10

NOTES:

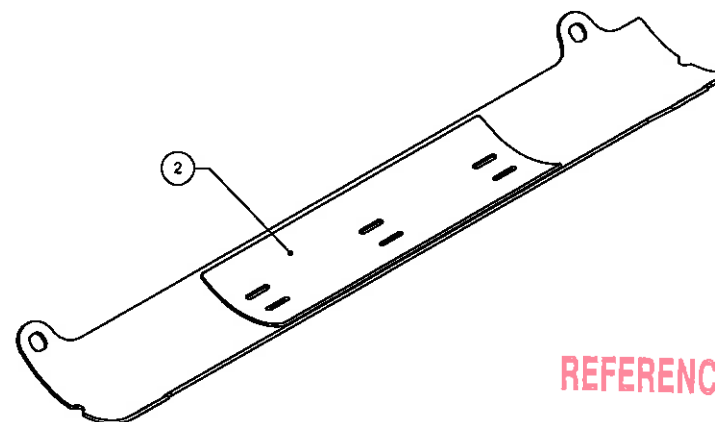
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5613 OR 5524 OR ASTM A240 18 GAUGE 0.050 THICK (REF DART SPEC. MS304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART Q81 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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ITEM	QTY	P/N	DESCRIPTION
	X	D3512-041	WEARPLATE ASSY
1	1	D3512-1	WEARPLATE
2	1	D3512-3	SPACER
3	A/R	8259 \ 2059B	HARD SURFACING



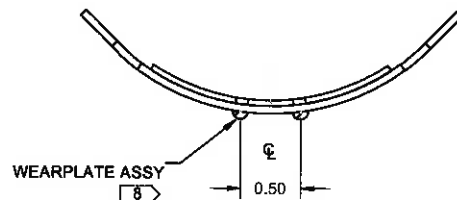
D3512-041 WEARPLATE ASSY



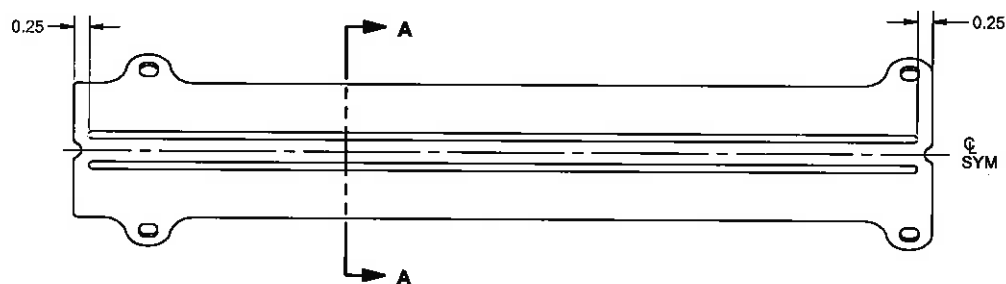
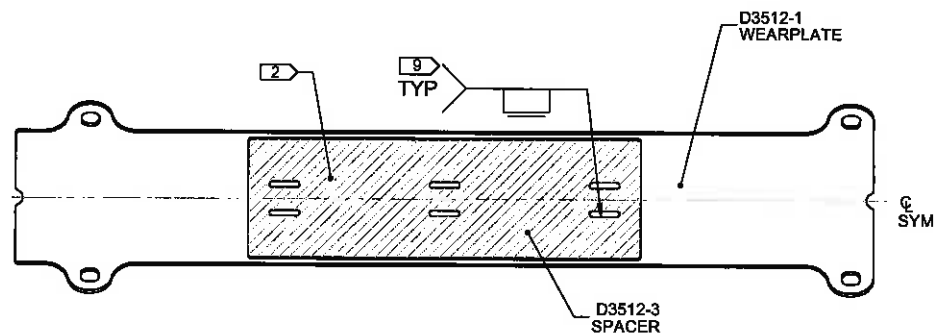
REFERENCE ONLY

E	ADJUSTED WIDTH OF PART FOR FIT AND FUNCTION, DIM 3.63 WAS 3.84 (ZN D3-3). UPDATE NOTE 8 (ZN A8-2), ADD NOTCHES (ZN D3-3 & D8-3). CHANGE SLOT'S TO QTY 6 AND LENGTH TO 0.5 (ZN D4-4). GENERAL UPDATE OF DRAWING TO CURRENT STANDARDS.	SAD	18.03.07
D	ADD D3512-041 AND D3512-3	DW	13.08.28
C	ENLARGE OBOROUND FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE USA, INC. HILLSBORO, OR	
DRAWN	SAD		
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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WORK IN PROGRESS



SECTION A-A 
SCALE 2X



D3512-041 WEARPLATE ASSY

REFERENCE ONLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT HATCHED (CONCAVE) SURFACE WITH TEXTURED COATING, 0.02-0.04 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.87 lbs
- 8) APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR APPLY HARD SURFACING WELD BEAD 0.06 - 0.13 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) WELD PER QSI 004

WORK IN PROGRESS

DESIGN	DW	DART AEROSPACE USA, INC.	
DRAWN	SAD	HILLSBORO, OR	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 16 GAUGE 0.063 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. MS304S16GA

- 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.62 lbs

REFERENCE ONLY

WORK IN PROGRESS

DESIGN	DW	DART AEROSPACE USA, INC.	
DRAWN	SAD	HILLSBORO, OR	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3512	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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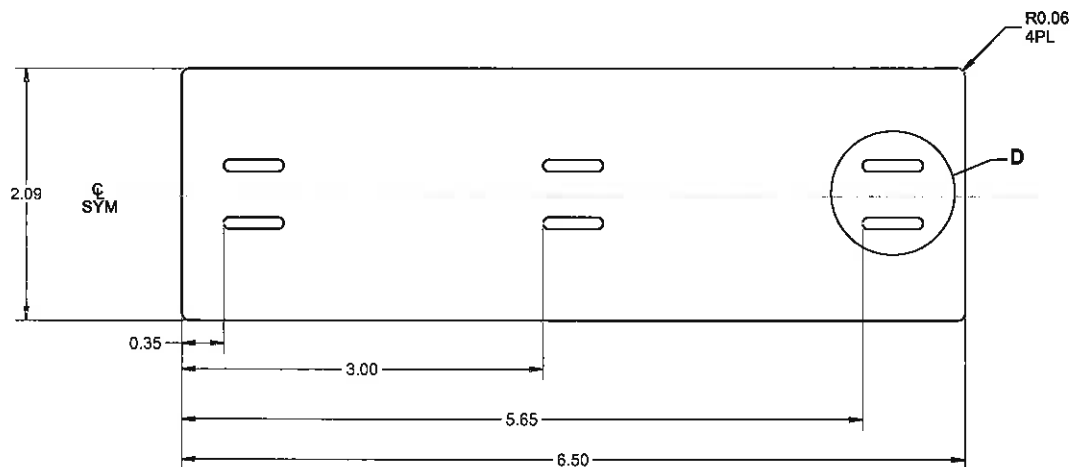
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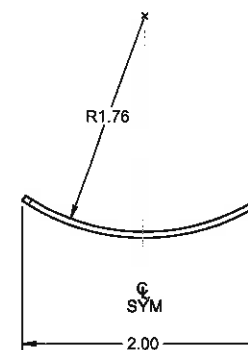
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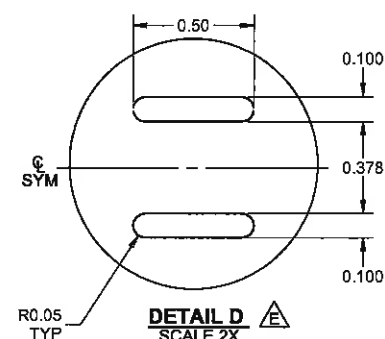
1



D3512-3F SPACER 
(FLAT PATTERN)



D3512-3 SPACER
(MAKE FROM D3512-3F)



DETAIL D 
SCALE 2X
3 PL

REFERENCE ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 18 GAUGE 0.050 THICK
PER MIL-S-6059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. MS304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

WORK IN PROGRESS

DESIGN	DW	DART AEROSPACE USA, INC.	
DRAWN	SAD	HILLSBORO, OR	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	DD	D3512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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Entered: 2K Date: Oct 23/19



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7489

Route update only ☐

Job: <u>201578</u> Part No. <u>D3512-041</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier Quality ☐																														
Date :		Sequence #:		QTY Affected : <u>12</u>		MRB (QSI042) DAS 51 9-89 <u>10/10/07</u>																												
Description Work Order Deviation				Disposition		Completed By																												
Make from D3512-041 Rev. E Rev. E Flat pattern is a minor deviation to Rev. D Flat pattern to allow part to be properly bent to Rev. D. Change in manufacturability only, no change to final bent shape per Rev. D. <u>9/19/19/9</u>				Acceptable to make from D3512-041 at Rev. E - D3512-041 Rev. E was made to fix a fit issues from D3512-041 Rev. D Ref: w/o 193591		<u>EL</u> <u>19-10-9</u> Lead hand / Supervisor <u>EL</u> <u>19-10-9</u> QC / QA Coordinator DAS 55 9-89 OCT 09 2019																												
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☒ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>					☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☒ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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